

Date: Friday, 24/10/2008 3:29:49 PM  
 User: Julie Dawson

## Process Sheet

|                       |                                       |                             |  |                                 |  |
|-----------------------|---------------------------------------|-----------------------------|--|---------------------------------|--|
| Customer              | : CU-DAR001 Dart Helicopters Services |                             | Drawing Name   | : 350 SKIDTUBE EXTRUSION (BENT) |  |
| Job Number            | : 42940                               |                             | Part Number  | : D26003BENT                    |  |
| Estimate Number       | : 10997                               |                             | Drawing Number   | : D2600 D1/D2750 F              |  |
| P.O. Number           | :                                     |                             | Project Number   | : N/A                           |  |
| This Issue            | : 24/10/2008                          | S.O. No. : <i>Skidtubes</i> | Drawing Revision   | : D1/F                          |  |
| Prsh Rev.             | : NC                                  |                             | Material   | :                               |  |
| First Issue           | : / /                                 |                             | Due Date   | : 15/10/2008                    |  |
| Previous Run.         | : 42342                               |                             | Qty:   | 16 Um: Each                     |  |
| Written By            | :                                     |                             | <i>DD</i>  |                                 |  |
| Checked & Approved By | : <i>DD</i>                           |                             | 8-10-30  |                                 |  |
| Comment               | : Est. B02.11.28 Rerformat KJ         |                             | Est Rev:C 08-09-30 D2750 revF as per dwg DD verified by:EC |                                 |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :   |              |                    |
|---------|-----------------------|---|--------------|--------------------|
| 1.0     | D26003120             | Extrusion Round 3" 350  |              |                    |
|         |                       | Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)<br>Extrusion Bent  |              |                    |
|         |                       | Pick:<br>Qty Part Number Description Batch  | <i>37756</i> | <i>FT 08-10-30</i> |
| 2.0     | BENDING               | BENDING MACHINE - SKIDTUBES   |              |                    |
|         |                       | Comment: BENDING MACHINE<br>Deburr one end of extrusion<br>Drill #30 pilot holes using DT8689<br>Open holes to 5/16" and deburr<br>Bend using CNC bending machine as per program 2750.C and Folio FT003.<br>Use 5/16 locator pin on buggy "A".<br>Check fit to Jig DT8150 |              | <i>FT 08-10-31</i> |
| 3.0     | QC5                   | INSPECT WORK TO CURRENT STEP  |              |                    |
|         |                       | Comment: INSPECT WORK TO CURRENT STEP<br>Inspect work to Step 6 Ensure fit to Jig DT8150  | <i>DP</i>    | <i>8-11-3</i>      |
| 4.0     | PACKAGING 1           | PACKAGING RESOURCE #1   |              |                    |
|         |                       | Comment: PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: <i>LG skidtube all</i>  | <i>DP</i>    | <i>8-11-3</i>      |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D2600-3-BENT PAR #: N/A Fault Category: Press Skid Bebe NCR: Yes No DQA: H Date: 08-11-04  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: J Date: 08/11/11

| NCR: 42940 |      | WORK ORDER NON-CONFORMANCE (NCR)  |                             |                                  |                |                           |                       |                          |
|------------|------|---|-----------------------------|----------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE       | STEP | Description of NC<br>Section A  | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|            |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng  | Sign &<br>Date |                           |                       |                          |
| 08-10-31   | 20.  | First Bend machine was cold underbent tube after successful bend tried to re-bend tube and even turn up program tube ended up crushing Q5/14/12 | J                           | Scrap + replace<br>Qty 1 B 37756 | ZT<br>08-10-31 | J                         | J                     | J                        |
|            |      | R.C. Machine mal function   |                             |                                  |                | 08-10-31                  | 08/10/12              | 08-10-31                 |
|            |      |   |                             |                                  |                |                           |                       |                          |
|            |      |   |                             |                                  |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 3:29:49 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

Job Number: 42940

Part Number: D26003BENT

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                      |                        |   |                        |
|----------------------|------------------------|---|------------------------|
| DESIGN<br><i>DKY</i> | DRAWN BY<br><i>DKY</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>KE</i> | APPROVED<br><i>SAS</i> | DRAWING NO.<br>D2600                              | REV. D<br>SHEET 1 OF 5 |
| DATE<br>98.08.20     |                        | TITLE<br>EXTRUSION                                | SCALE<br>1:1           |
| A                    | 97.01.21               | NEW ISSUE   |                        |
| B                    | 97.09.09               | CHANGE MATERIAL SPEC.                             |                        |
| C                    | 98.04.16               | ADD D2600-3, UPDATE D2600-1 WIDTH,<br>ADD DIE NO. |                        |
| D                    | 98.08.20               | INCREASE MIN. UTS TO 40 KSI                       |                        |
| DI                   | 01.04.17               | ADD PART NUMBERS & DIE NUMBERS                    | <i>+ CP</i>            |

**RELEASED**  
*18.08.25 DS*
GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
 TO ASTM STANDARD B221 BY AN APPROVED TESTING  
 FACILITY TO ENSURE THAT THE BATCH MEETS THE  
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE  
 NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 42940

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

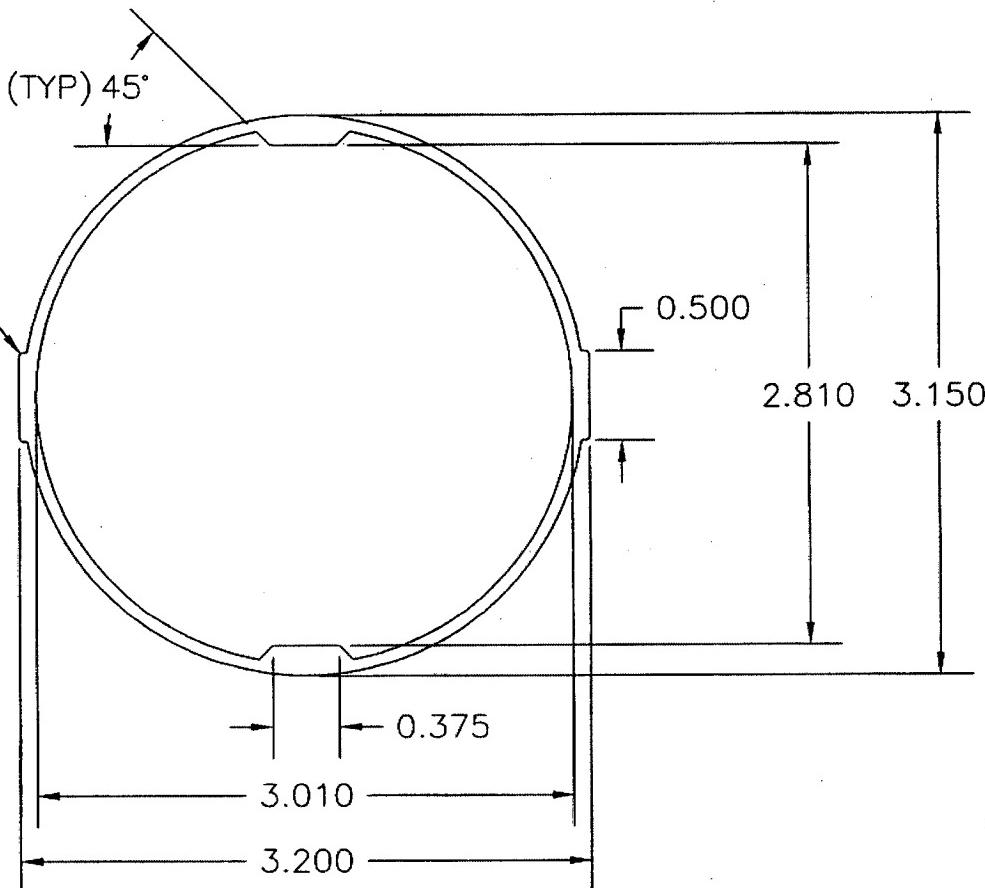
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                      |                       |   |
|----------------------|-----------------------|---|
| DESIGN<br><i>M</i>   | DRAWN BY<br><i>M</i>  | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>KE</i> | APPROVED<br><i>JF</i> | DRAWING NO.<br>D2600                              |
| DATE<br>98.08.20     | TITLE<br>EXTRUSION    | SHEET 2 OF 5<br>SCALE<br>1:1                      |

**RELEASED**  
98.8.25 DS

D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870  
OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 12640

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

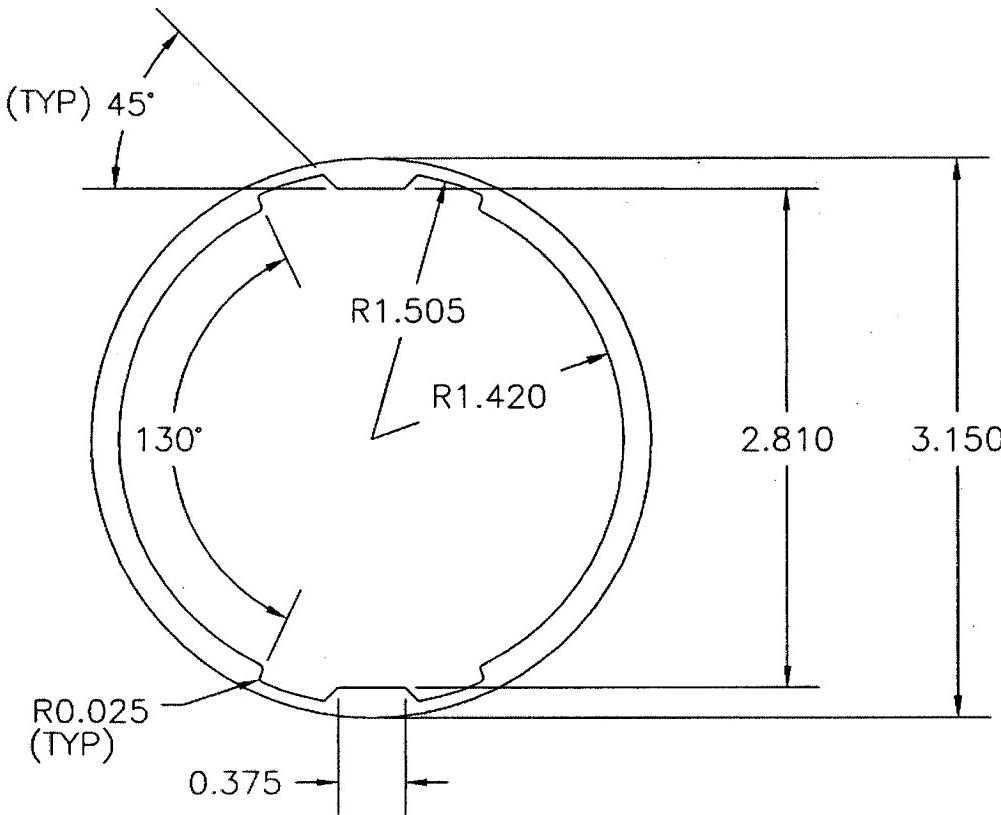
NOTE: Date & initial all entries

**DART**



|                      |                       |  |
|----------------------|-----------------------|--|
| DESIGN<br><i>MW</i>  | DRAWN BY<br><i>MW</i> | DART AEROSPACE LTD.<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>KE</i> | APPROVED<br><i>JH</i> | DRAWING NO.<br>D2600                               |
| DATE<br>98.08.20     | TITLE<br>EXTRUSION    | REV. D<br>SHEET 3 OF 5<br>SCALE<br>1:1             |

**RELEASED**  
98.8.15 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859  
OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. WCPA 2600-3  
DI

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

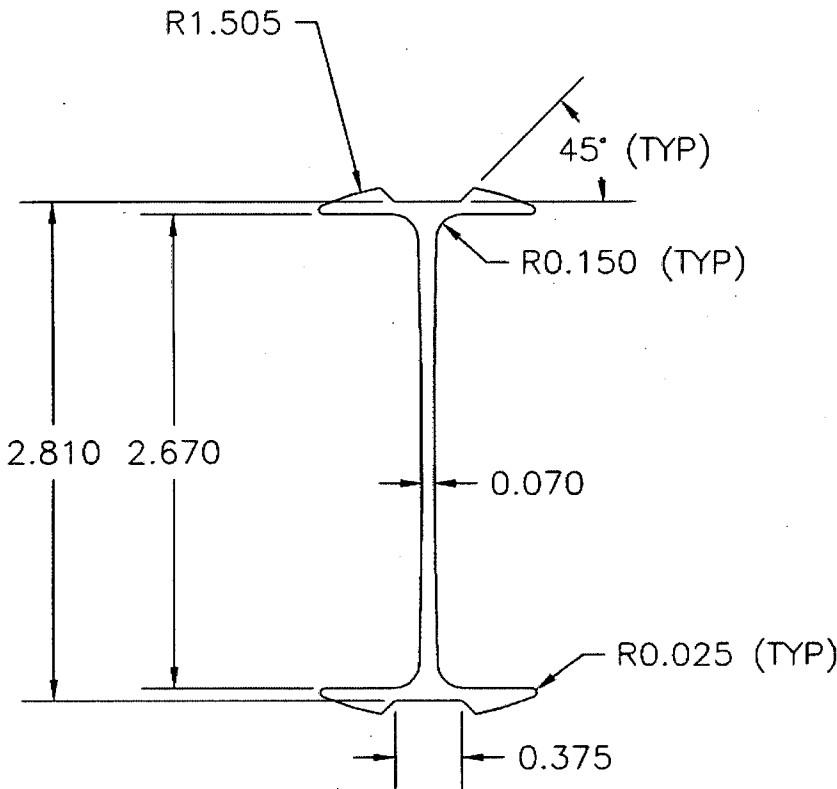
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART****RELEASED**  
98.8.25. DS

|                      |                       |   |
|----------------------|-----------------------|---|
| DESIGN<br><i>W</i>   | DRAWN BY<br><i>SM</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>KE</i> | APPROVED<br><i>J</i>  | DRAWING NO.<br>D2600                              |
| DATE<br>98.08.20     | TITLE<br>EXTRUSION    | REV. D<br>SHEET 4 OF 5<br>SCALE<br>1:1            |

D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. W2600

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

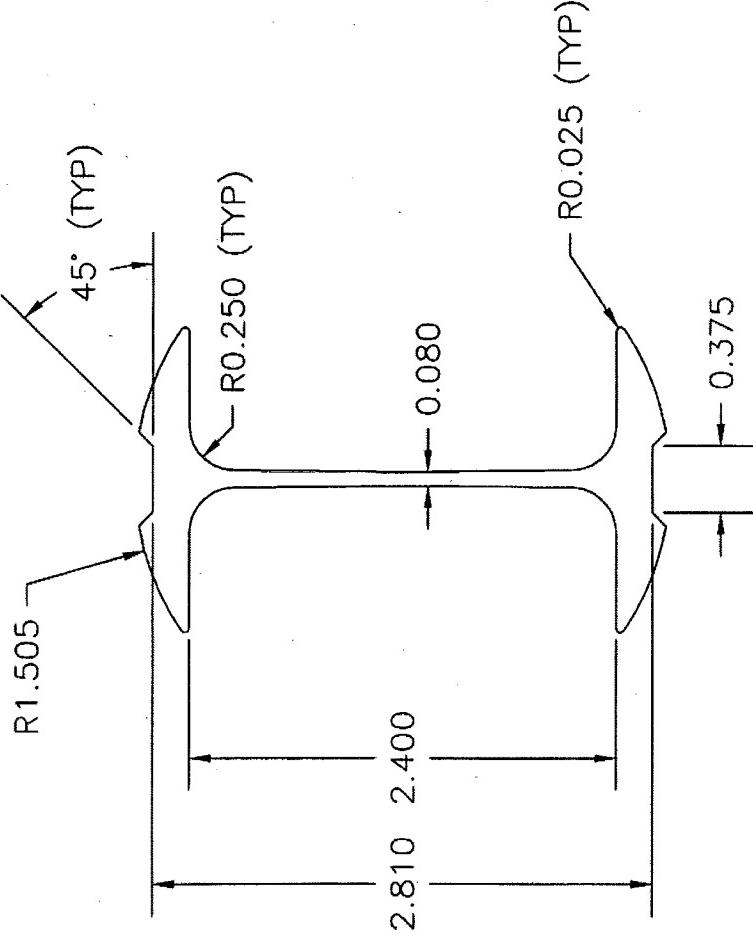
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                      |                       |   |              |              |
|----------------------|-----------------------|---|--------------|--------------|
| DESIGN<br><i>DKS</i> | DRAWN BY<br><i>DS</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |              |
| CHECKED<br><i>KE</i> | APPROVED<br><i>S</i>  | DRAWING NO.<br>D2600                              | REV. D       | SHEET 5 OF 5 |
| DATE<br>98.08.20     |                       | TITLE<br>EXTRUSION                                | SCALE<br>1:1 |              |

**RELEASED**  
98.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 112940

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

| QTY<br>-041 | QTY<br>-042 | QTY<br>-043 | QTY<br>-044 | PART NUMBER   | DESCRIPTION  |
|-------------|-------------|-------------|-------------|---------------|--|
| X           |             |             |             | D2750-041     | 350 SKIDTUBE ASSEMBLY, LH                                  |
|             | X           |             |             | D2750-042     | 350 SKIDTUBE ASSEMBLY, RH                                  |
|             | X           |             |             | D2750-043     | 350 SKIDTUBE ASSEMBLY, LH                                  |
|             | X           |             |             | D2750-044     | 350 SKIDTUBE ASSEMBLY, RH                                  |
| 1           | 1           | 1           | 1           | D2739         | WEB  |
| 8           | 8           | 8           | 8           | D2743         | SPACER   |
| 1           | 1           | 1           | 1           | D2744         | CAP  |
| 8           | 8           | 8           | 8           | D2745         | BUSHING  |
| 1           |             |             |             | D2750-1       | SKIDTUBE WELDMENT, LH                                      |
|             | 1           |             |             | D2750-2       | SKIDTUBE WELDMENT, RH                                      |
|             | 1           |             |             | D2750-3       | SKIDTUBE WELDMENT, LH                                      |
|             | 1           |             |             | D2750-4       | SKIDTUBE WELDMENT, RH                                      |
| 1           | 1           |             |             | D3488-041     | BLADE FITTING, LH  |
|             | 1           |             |             | D3488-042     | BLADE FITTING, RH  |
| 4           | 4           | 4           | 4           | D3490-1       | SPACER   |
| 4           | 4           |             |             | D3490-3       | SPACER   |
|             | 4           | 4           | 4           | D3490-5       | SPACER   |
| 8           | 8           | 8           | 8           | D3492-041     | PLUG ASSEMBLY  |
| 8           | 8           |             |             | D3492-043     | PLUG ASSEMBLY  |
|             | 8           | 8           | 8           | D3492-045     | PLUG ASSEMBLY  |
| 1           | 1           | 1           | 1           | D3535-25      | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3536-25      | GASKET   |
| 3           | 3           | 3           | 3           | D3537-1       | WEARPAD  |
| 8           | 8           | 8           | 8           | D3631-1       | WASHER   |
| 1           | 1           | 1           | 1           | D3791-1       | WEARPLATE  |
| 1           | 1           | 1           | 1           | D3793-1       | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3793-3       | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3794-1       | GASKET   |
| 1           | 1           | 1           | 1           | D3794-3       | GASKET   |
| 38          | 38          | 38          | 38          | ALS4-1032-225 | INSERT (OR ALS7-1032-225,<br>AKS4-1032-225, AELS-1032-225) |
| 34          | 34          | 34          | 34          | AN3C5A        | BOLT   |
| 4           | 4           | 4           | 4           | AN3C6A        | BOLT   |
| 4           | 4           | 4           | 4           | AN6C44A       | BOLT   |
| 1           | 1           | 1           | 1           | AN8C35A       | BOLT   |
| 38          | 38          | 38          | 38          | AN960C10L     | WASHER   |
| 1           | 1           | 1           | 1           | AN960C816L    | WASHER   |
| 4           | 4           | 4           | 4           | MS21043-6     | NUT  |
| 1           | 1           | 1           | 1           | MS21083C8     | NUT  |
| 4           | 4           | 4           | 4           | NAS1515H3L    | WASHER   |

**GENERAL NOTES:**

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL ▲
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL ▲

|            |   |  |               |
|------------|---|--|---------------|
| F          | INCORPORATE DS1 9413;<br>QTY (3) D3537-1 WAS QTY (5) (ZN C8-1);<br>D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1);<br>D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1);<br>ADD D3791-1 (ZN C8-1);<br>WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED<br>(8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1);<br>D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11);<br>ADD NOTE 12 AND 13 (ZN A6-1);<br>REASON: REF. NCR 08-043 | PH   | 08.07.16      |
| E          | CHANGE TO STAINLESS STEEL WEARPLATES;<br>ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1;<br>REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10)<br>NAS1515H8L; REMOVE D2741, QTY (2) AN960C816;<br>REMOVE QTY (2) MS21083C8  | CB   | 07.05.17      |
| D          | ADD HOLES AND SPACERS FOR APICAL FLOATS;<br>INCORPORATE DEO 9133/9157   | PH   | 06.01.05      |
| C          | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740  | CP   | 98.11.18      |
| B          | CHANGE MS24694-S293 TO AN8-16A  | CP   | 98.09.01      |
| A          | NEW ISSUE   | DS   | 98.04.16      |
| REV.       | DESCRIPTION   | BY   | DATE          |
| DESIGN     | PL  | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |               |
| DRAWN      | PL  |  |               |
| CHECKED    | PL  | DRAWING NO.                                  | REV. F        |
| MFG. APPR. | PL  | D2750  | SHEET 1 OF 11 |
| APPROVED   | PL  | TITLE  |               |
| DE APPR.   | PL  | 350 SKIDTUBE ASSEMBLY                        |               |
| DATE       | 08.07.16  | SCALE  | NTS           |

Copyright © 1998 by Dart Aerospace USA, Inc.  
This document is private and confidential and is supplied on the express condition that it is  
not to be used for any purpose or copied or communicated to any other person without  
written permission from Dart Aerospace USA, Inc.

RELEASED  
6/27/22 M

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42040

8 7 6 5 4 3 2 1

D

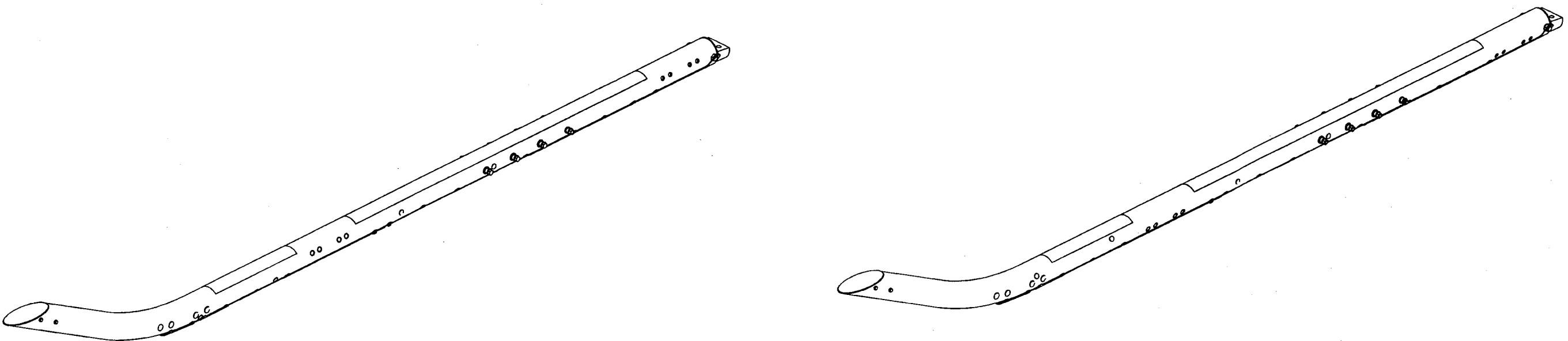
D

C

C

B

B



D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 42940

**RELEASED**  
*08-07-16*

|            |           |                          |                       |
|------------|-----------|--------------------------|-----------------------|
| DESIGN     | <i>PW</i> | DART AEROSPACE USA, INC. |                       |
| DRAWN      | <i>AJ</i> | PORT HADLOCK, WA         |                       |
| CHECKED    | <i>AB</i> | DRAWING NO.              |                       |
| MFG. APPR. | <i>AB</i> | REV. F                   |                       |
| APPROVED   | <i>MJ</i> | D2750                    |                       |
| DE APPR.   | <i>MJ</i> | SHEET 2 OF 11            |                       |
| DATE       | 08.07.16  | TITLE                    | 350 SKIDTUBE ASSEMBLY |
|            |           | SCALE                    | NTS                   |

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8

7

6

5

4

3

2

1

8 7 6 5 4 3 2 1

D

D

C

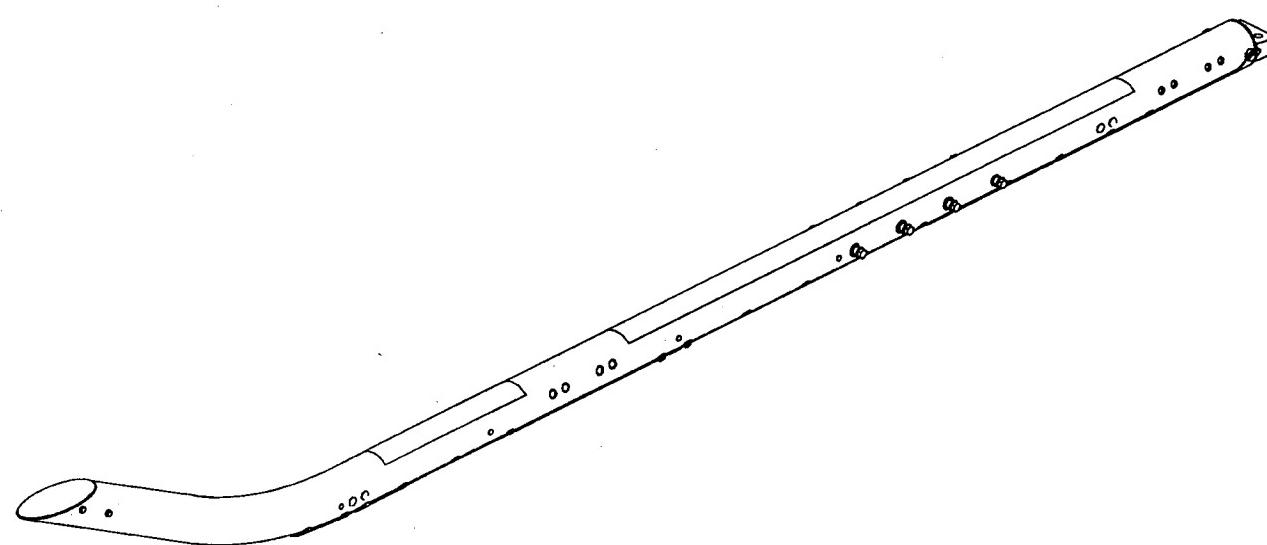
C

B

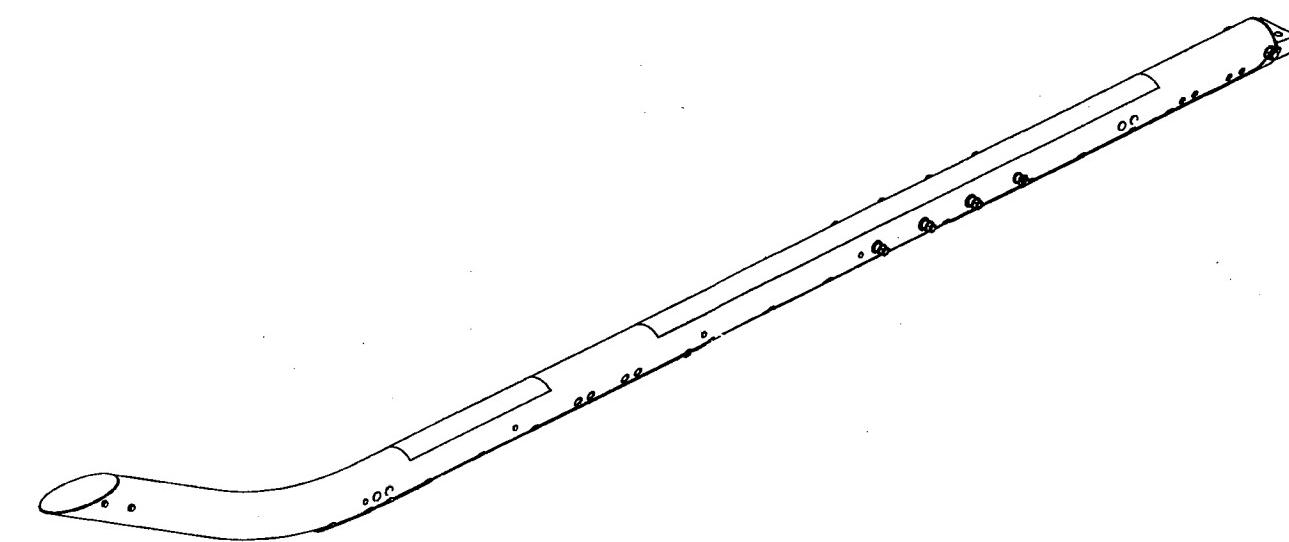
B

A

A



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

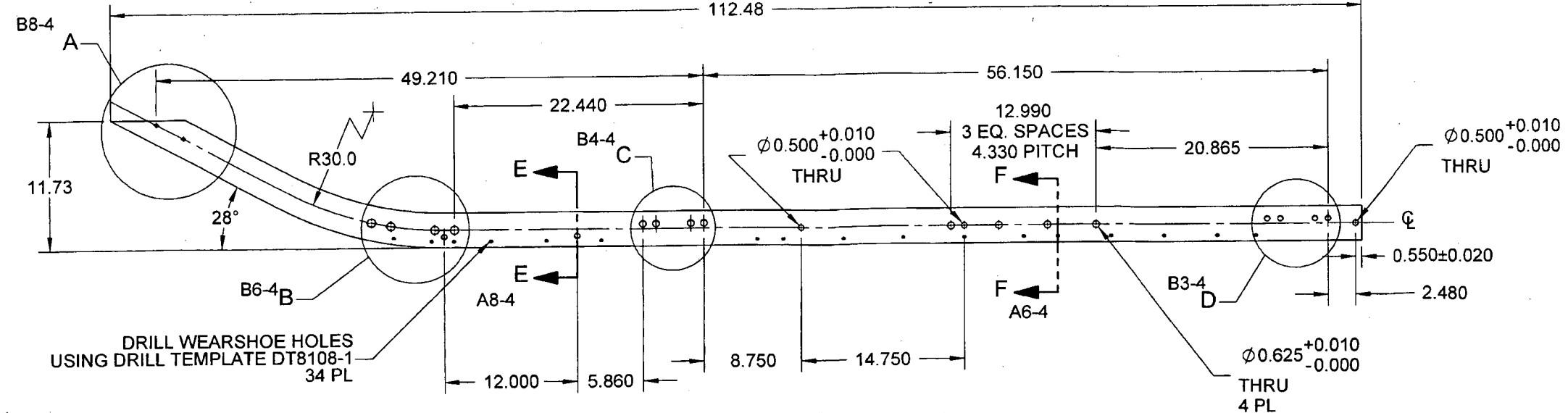
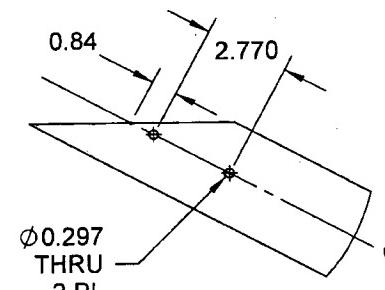
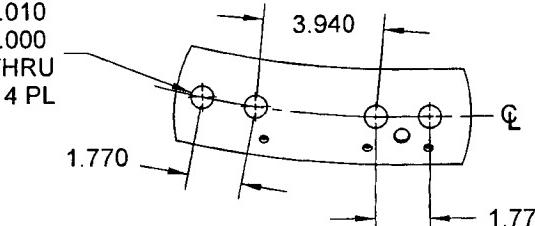
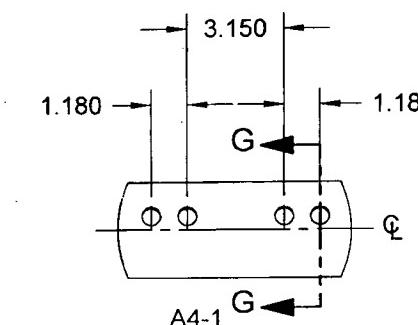
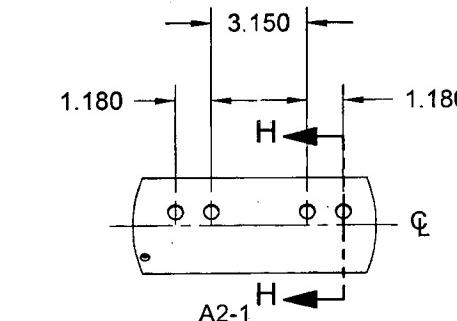
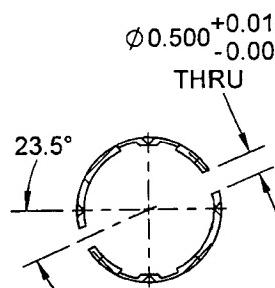
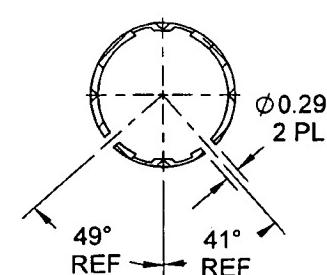
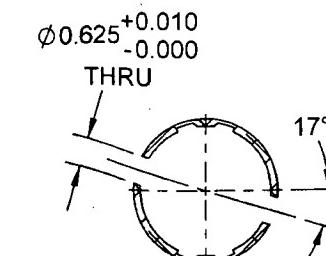
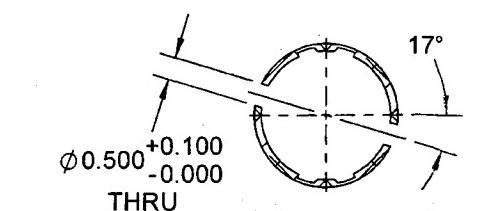
WORK ORDER

NO. 45940

**RELEASED**  
68-9-22/17

|   |          |                          |                       |
|---|----------|--------------------------|-----------------------|
| DESIGN  | Pd       | DART AEROSPACE USA, INC. |                       |
| DRAWN   | Pd       | PORT HADLOCK, WA         |                       |
| CHECKED   |          | DRAWING NO.              |                       |
| MFG. APPR.  |          | REV. F                   |                       |
| APPROVED  |          | D2750                    |                       |
| DE APPR.  |          | SHEET 3 OF 11            |                       |
| DATE  | 08.07.16 | TITLE                    | 350 SKIDTUBE ASSEMBLY |
|   |          | SCALE                    |                       |
|   |          | NTS                      |                       |
| COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |          |                          |                       |

8 7 6 5 4 3 2 1

D2750-1 LH SKIDTUBEDETAIL A  
SCALE 2XDETAIL B  
SCALE 2XDETAIL C  
SCALE 2XDETAIL D  
SCALE 2XSECTION E-E  
SCALE 3X, 2 PLSECTION F-F  
SCALE 3X, 17 PLSECTION G-G  
SCALE 3X, 4 PLSECTION H-H  
SCALE 3X, 4 PL**RELEASED**

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42940

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WAREV. F  
DRAWING NO.  
**D2750**

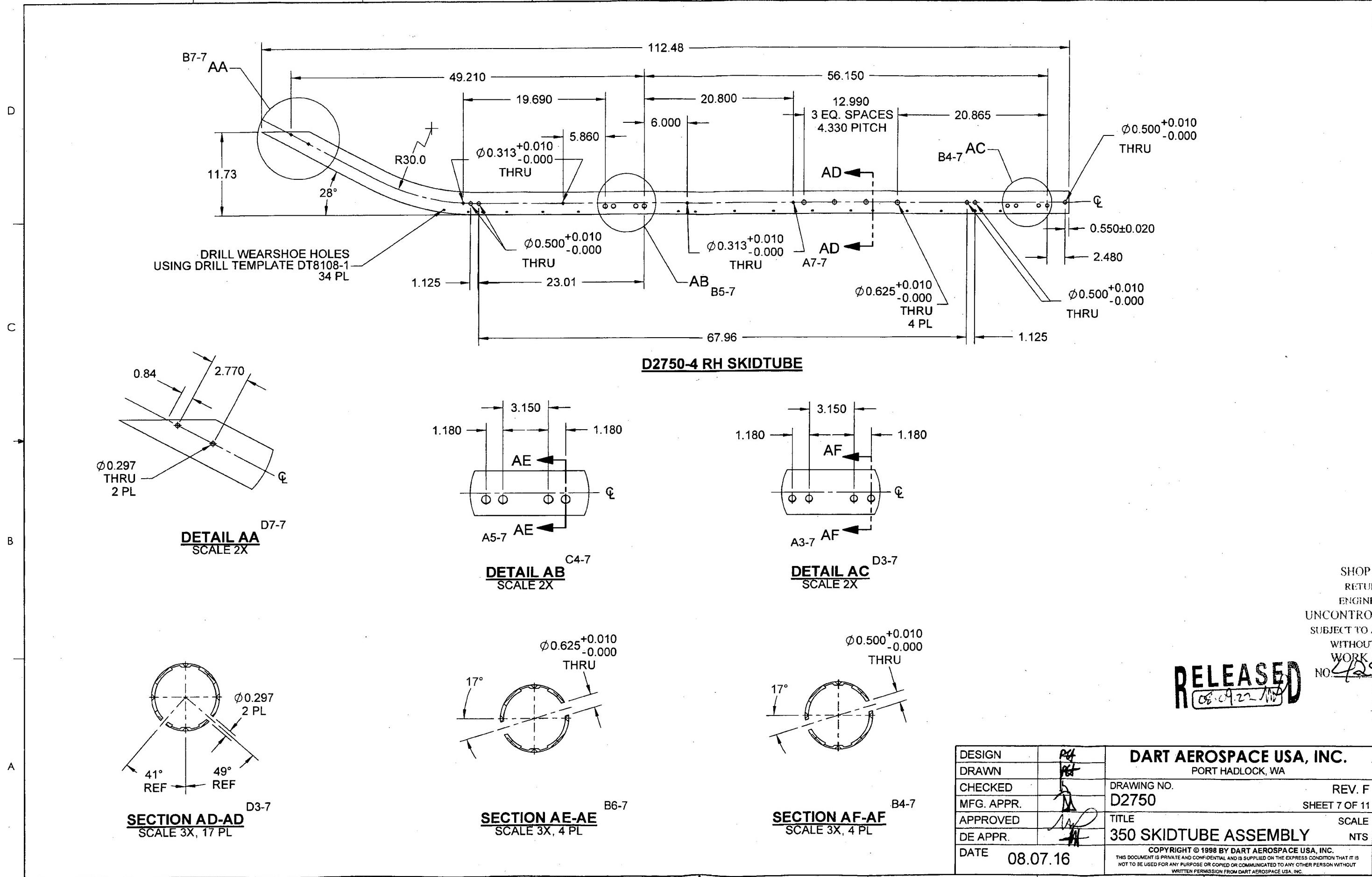
SHEET 4 OF 11

TITLE  
**350 SKIDTUBE ASSEMBLY**SCALE  
NTS

|            |          |
|------------|----------|
| DESIGN     | P#       |
| DRAWN      | P#       |
| CHECKED    |          |
| MFG. APPR. |          |
| APPROVED   |          |
| DE APPR.   |          |
| DATE       | 08.07.16 |

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8 7 6 5 4 3 2 1



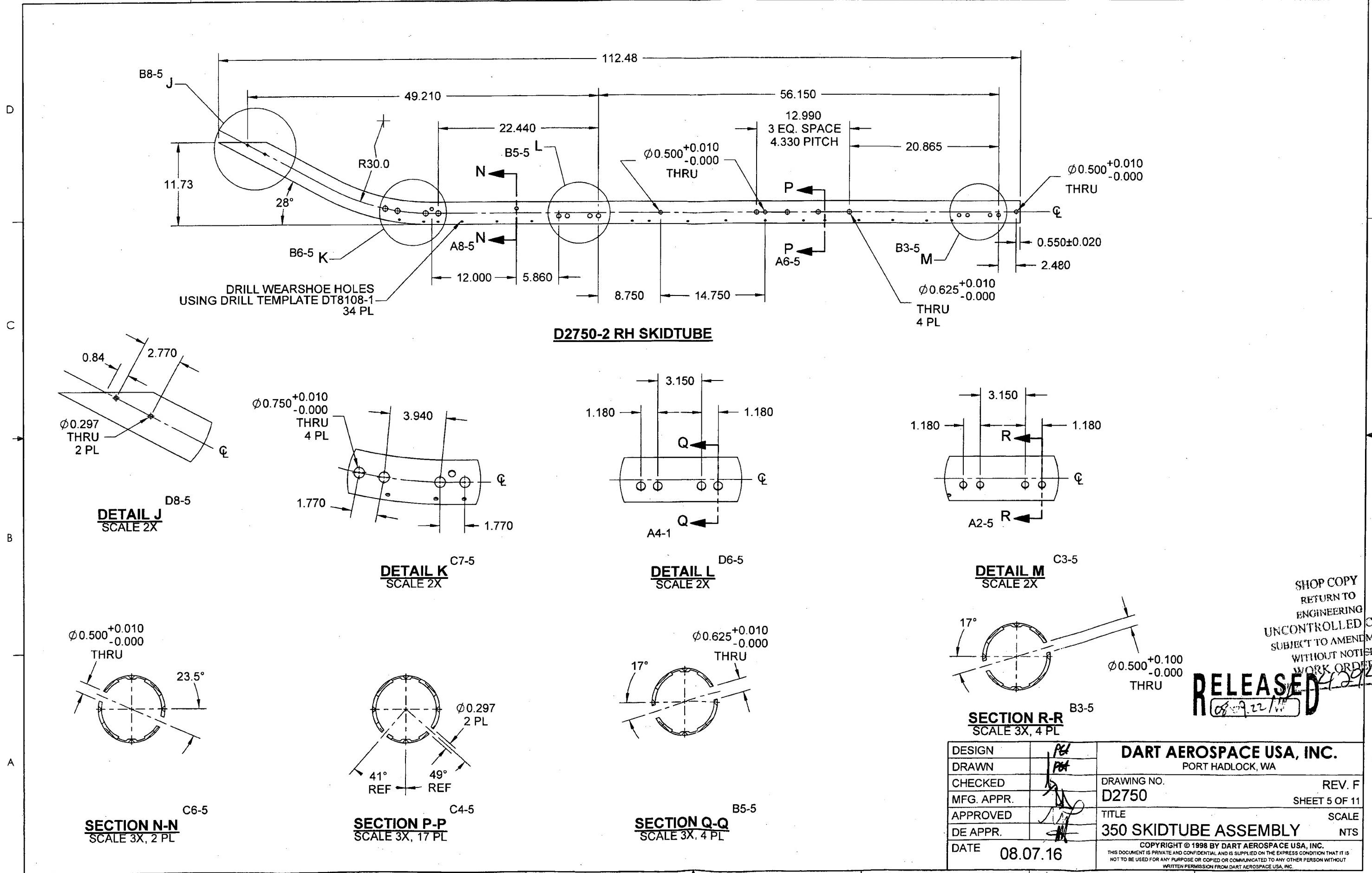
D

C

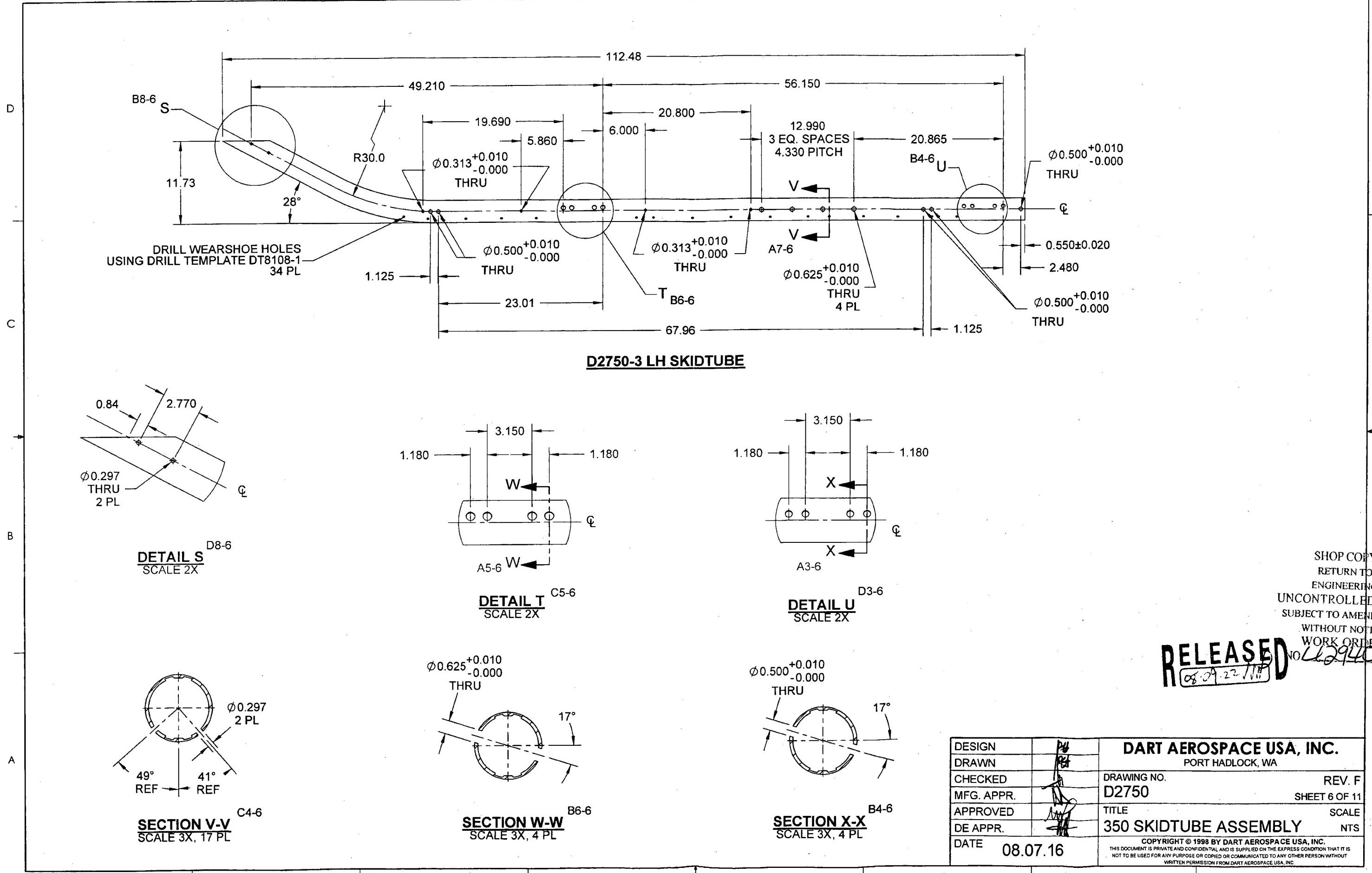
B

A

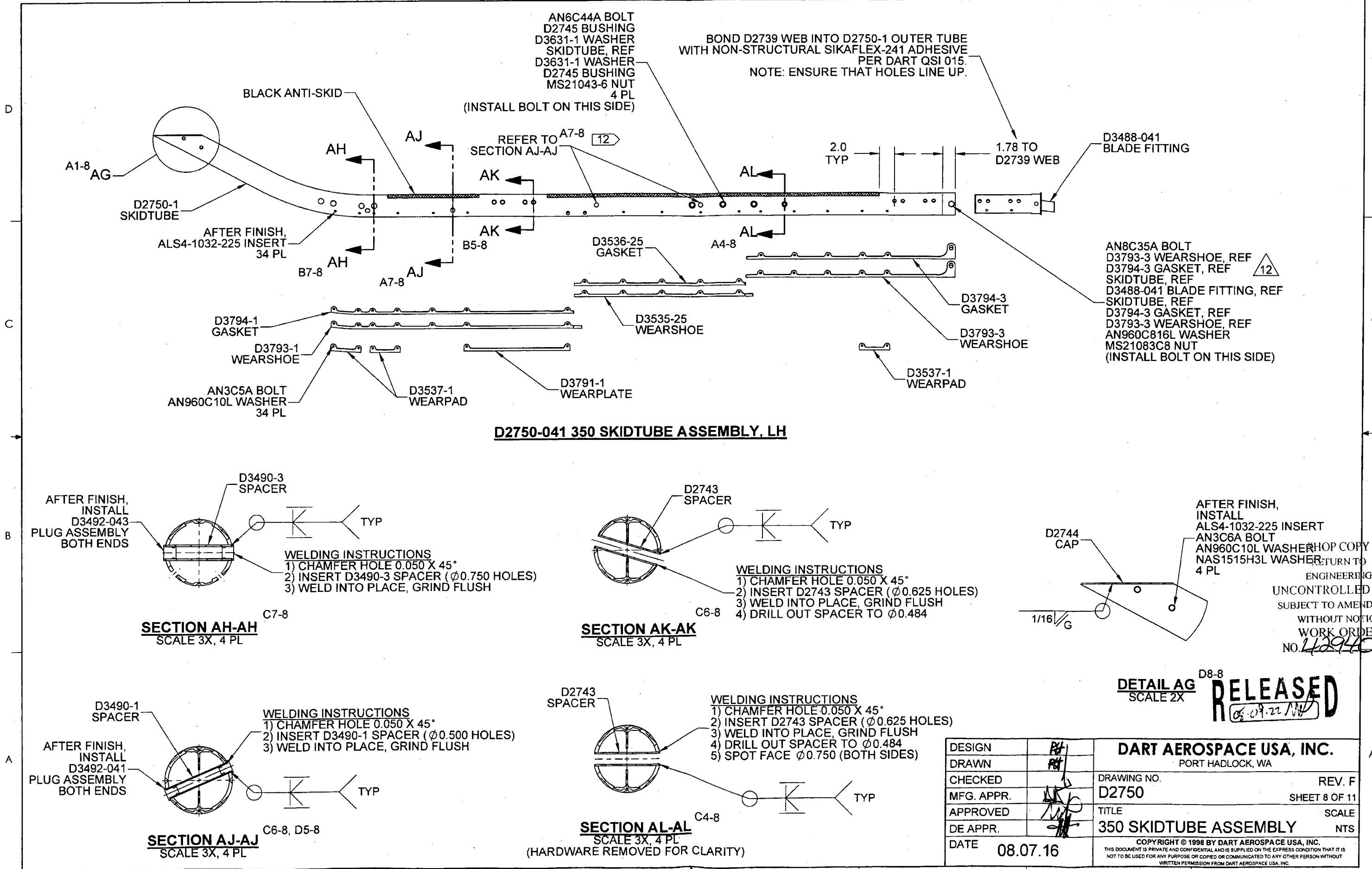
8 7 6 5 4 3 2 1

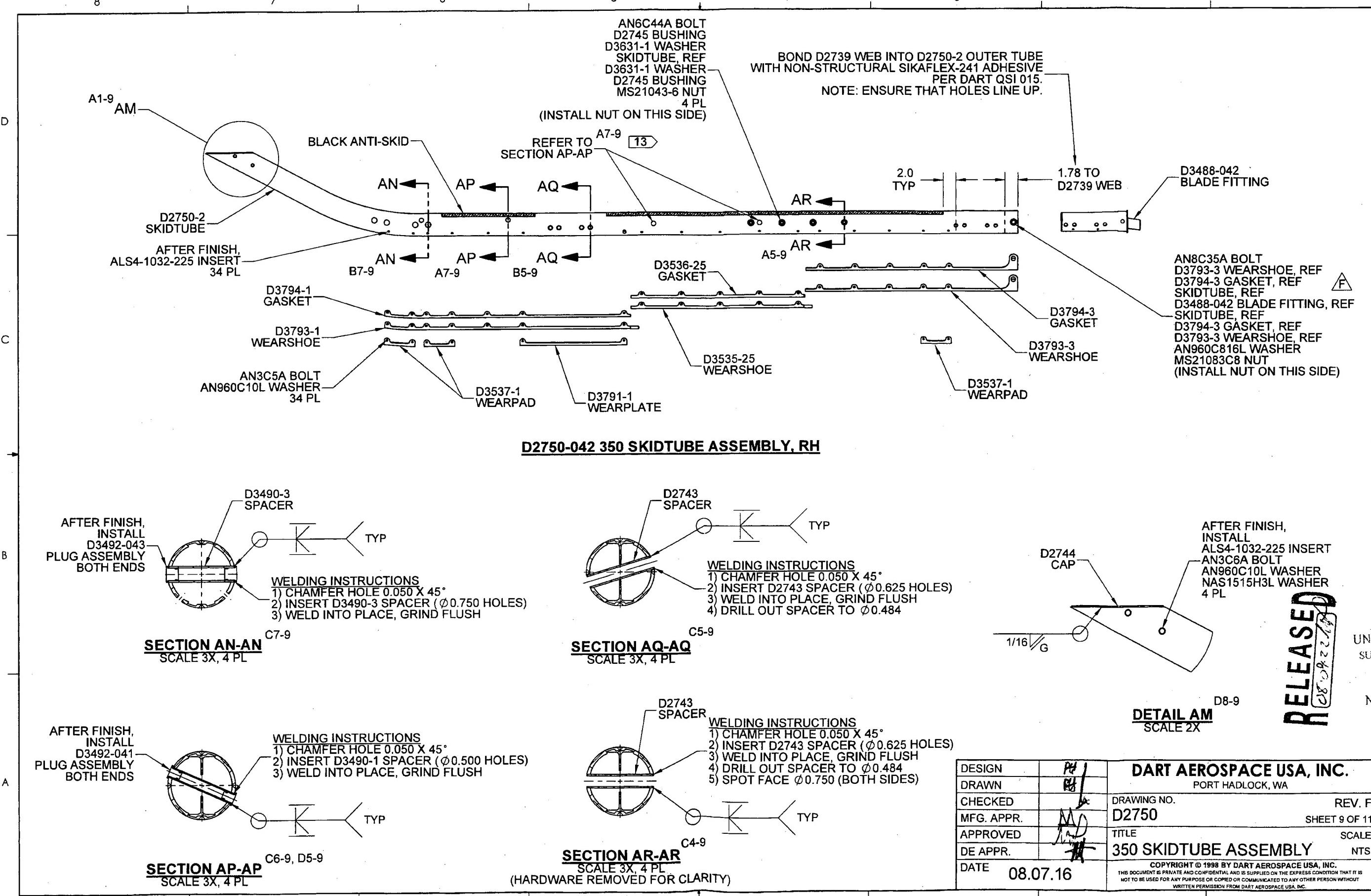


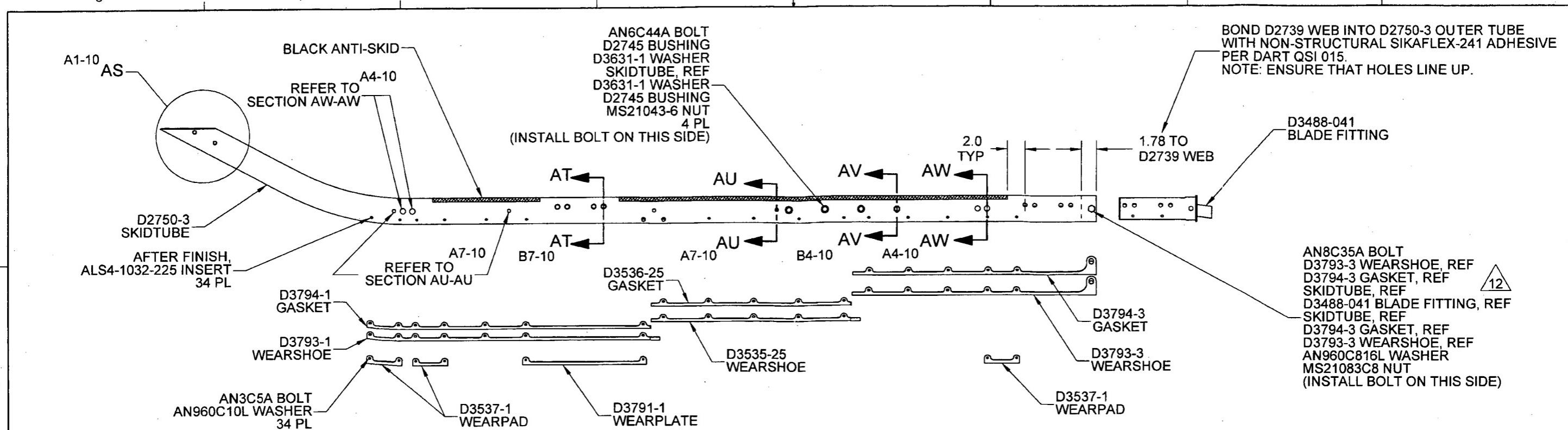
8 7 6 5 4 3 2 1



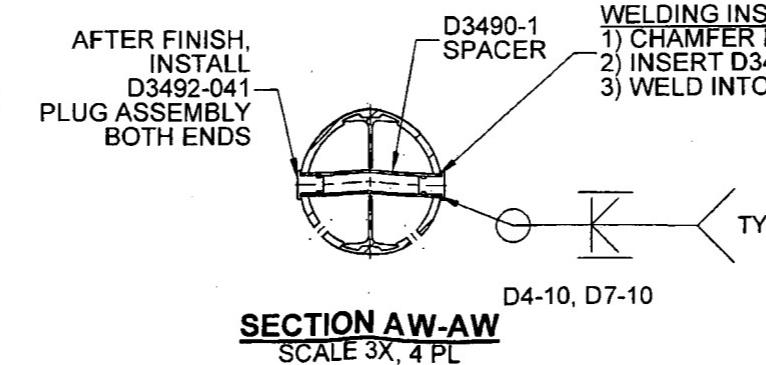
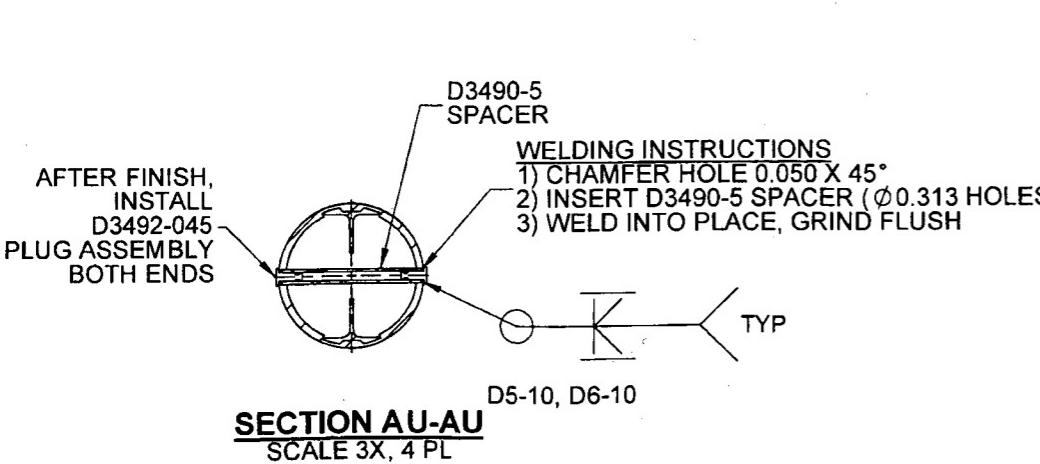
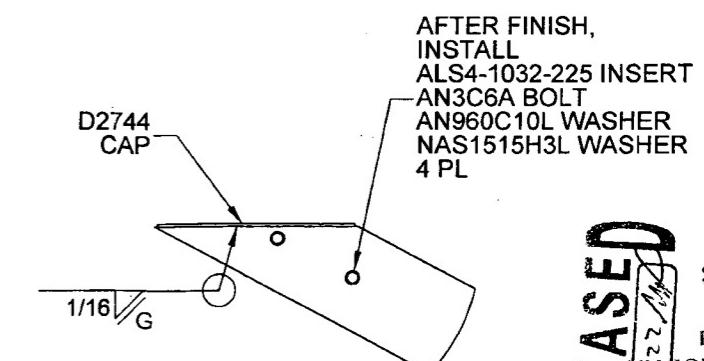
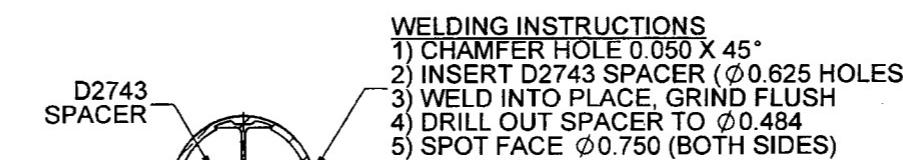
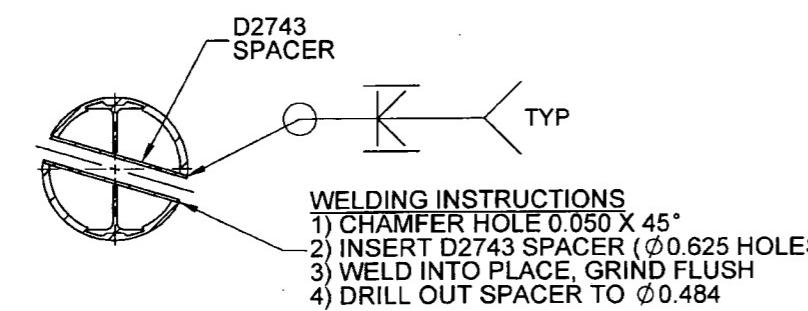
8 7 6 5 4 3 2 1







### D2750-043 350 SKIDTUBE ASSEMBLY, LH

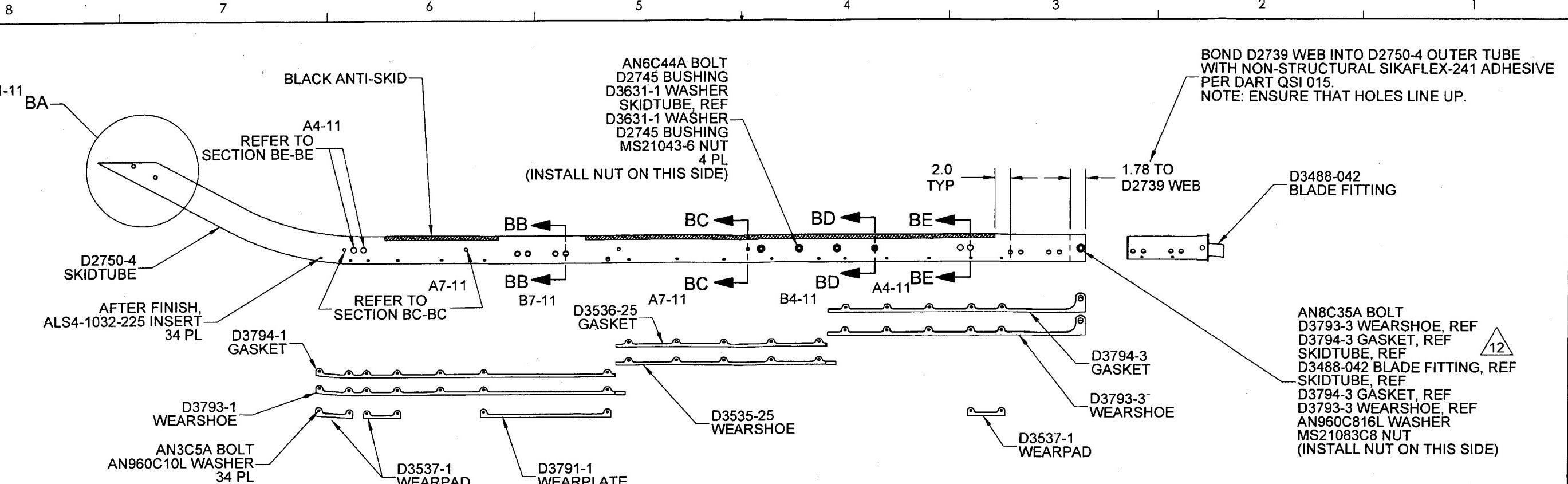


DETAIL AS  
SCALE 2X

|            |                |                          |
|------------|----------------|--------------------------|
| DESIGN     | <i>AB</i>      | DART AEROSPACE USA, INC. |
| DRAWN      | <i>P&amp;P</i> | PORT HADLOCK, WA         |
| CHECKED    | <i>1/2</i>     | DRAWING NO.              |
| MFG. APPR. | <i>MO</i>      | D2750                    |
| APPROVED   | <i>JW</i>      | REV. F                   |
| DE APPR.   | <i>JK</i>      | SHEET 10 OF 11           |
| DATE       | 08.07.16       | SCALE                    |
|            |                | NTS                      |

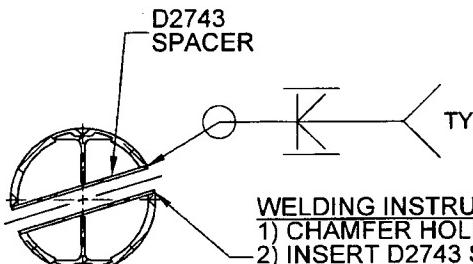
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED  
*4/20/00*  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *4/20/00*



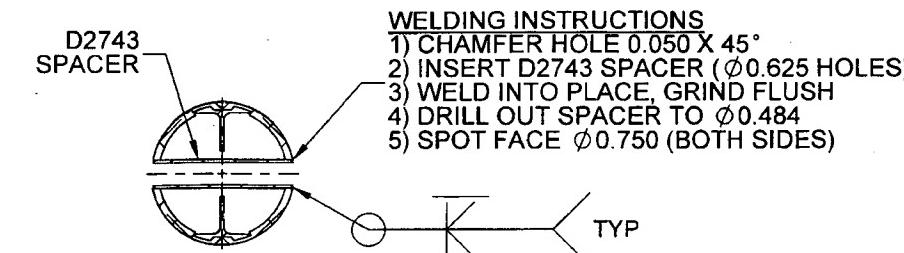
### D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED  
08.07.16



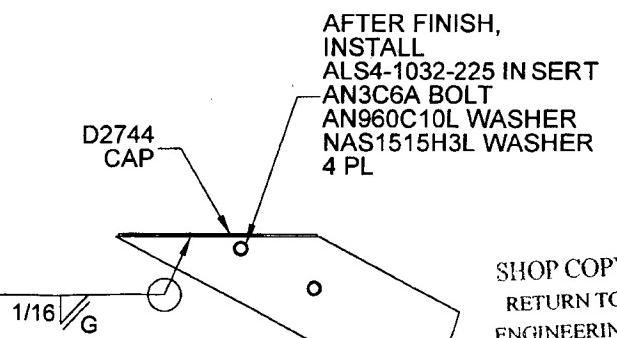
#### SECTION BB-BB

SCALE 3X, 4 PL



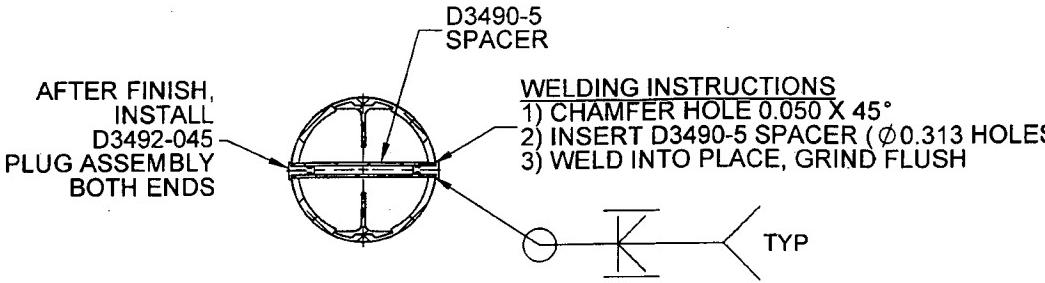
#### SECTION BD-BD

SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



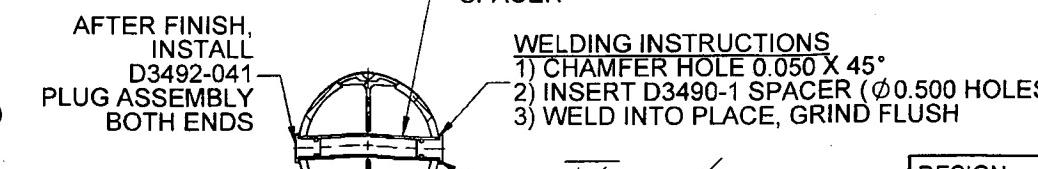
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

D8-11 WORK ORDER  
NO. 110240



#### SECTION BC-BC

SCALE 3X, 4 PL



#### SECTION BE-BE

SCALE 3X, 4 PL

|            |          |                          |
|------------|----------|--------------------------|
| DESIGN     | RE/      | DART AEROSPACE USA, INC. |
| DRAWN      | RE/      | PORT HADLOCK, WA         |
| CHECKED    | RE/      | REV. F                   |
| MFG. APPR. | RE/      | DRAWING NO.              |
| APPROVED   | RE/      | D2750                    |
| DE APPR.   | RE/      | TITLE                    |
| DATE       | 08.07.16 | 350 SKIDTUBE ASSEMBLY    |
|            |          | NTS                      |

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.